

# Work Order ID 71950

Thursday, July 14, 2011 10:02:29 AM



Page 1

Item ID: D3560-044

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm Weldment

Start Date: 7/14/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3560

Rev D

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 15.500" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA696 Rev AA & Dwg D3560 Rev: D  
2-C'sink 0.196" hole on manual mill as per dwg D3560  
3-Deburr per dwg D3560

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11/0426 8 0

SL 11-07-27 8 0

SL 11-07-27 8 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 71950**

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Page 2

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Revision ID:

Stop



Item Name: Arm Weldment

Start Date: 7/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00

B.A

11/07/28

8

φ



QC

Memo

0.00

Quality Control

140

Large Fab

0.00



Large Fab

Memo

0.00

8

φ

Large Fab

1-Weld assembly as per dwg D3560  
STEP:  
1- clean material (buff bracket and bottom of arm with blue pad )  
2- set up bracket and arm on jig  
3- preheat bracket and arm with torch  
4- clean before welding with brush  
5- set up machine to 135 amps  
6- weld across bottom and top ends  
7- reheat with torch ( 65 deg C )  
8- on one side weld from bottom to top half way  
9- same for other side (half way)  
10- from half way point weld the rest of the first side (ease off pedal near end)  
11- same for remaining side (ease off pedal near end)

11-08-03

W/O:		WORK ORDER CHANGES					
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**Work Order ID 71950**



Thursday, July 14, 2011 10:02:29 AM







Page 3

Item ID: D3560-044 Accept  Setup Start   
Revision ID:  
Item Name: Arm Weldment Stop   
Start Date: 7/14/2011 Start Qty: 4.00  Cust Item ID:  
Required Date: 7/22/2011 Req'd Qty: 4.00  Customer:

**Reference:**

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				 -084			
160  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00 0.00				8	0	824/08/04	
170  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				8X	0	M-L 11/08/02	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 71950**

Thursday, July 14, 2011 10:02:29 AM



Page 4

Item ID: D3560-044

Accept



Setup Start



Revision ID:

Stop



Item Name: Arm Weldment

Start Date: 7/14/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							
190  Small Fab Small Fab Small Fab	Small Fab  Memo 1-Press bushing in D3560 arm per dwg D3562	0.00  0.00							
200  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							

x8 6/11 1108/08

SP 11/08/10 (8)

8/10/08/11

(x8)

-044

W/O:		WORK ORDER CHANGES					
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Thursday, July 14, 2011 10:02:29 AM



Page 5

<b>Item ID:</b> D3560-044	<b>Accept</b>		<b>Setup</b>	<b>Start</b>	
<b>Revision ID:</b>				<b>Stop</b>	
<b>Item Name:</b> Arm Weldment					
<b>Start Date:</b> 7/14/2011	<b>Start Qty:</b> 4.00		<b>Cust Item ID:</b>		
<b>Required Date:</b> 7/22/2011	<b>Req'd Qty:</b> 4.00		<b>Customer:</b>		
<b>Reference:</b>					
<b>Approvals:</b>	<b>Process Plan:</b>	<b>Date:</b>	<b>Tooling:</b>	<b>Date:</b>	<b>Run</b>
	<b>QC:</b>	<b>Date:</b>	<b>SPC (Y/N):</b>	<b>Date:</b>	<b>Start</b>
					<b>Stop</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>WB</u>	0.00				8	0		
Packaging	<b>Memo</b>	0.00							
Packaging	*** STOCK IN STEP CELL ***								
220	QC21- Final Inspection - Work Order Release	0.00							
QC	<b>Memo</b>	0.00							
Quality Control									

*dy/Ae* 11.08.11

*CK* 11/08/12

11-08-11  
*(8)*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

Thursday, July 14, 2011 10:02:36 AM

**Parent Item Name:** Arm Weldment

**Required Date:** 7/22/2011

**Required Qty: 4.00**

<b>Comments:</b>	IPP Rev:A	New Issue	07.05.24	EC	
	IPP Rev B	ECN 987	07.10.09	EC	verified by DD
	IPP Rev:C	ECN1048	07-12-18	DD	veriffied by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2808		Manufactured	No			100	Each	17.0000	1	4			
Bushing													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				2					
				32896				2					
				ST023				15					
				69609				3					
				69892				12					
M6061T6B0.500X05.00		Purchased	No			140	f	35.1350	1.295	5.452632			
0													
6061-T6 Bar .500 x 5.00													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT004				35.135					
				112154				6.935					
				117933				28.2		10.33			
D3592-1		Manufactured	No			190	Each	49.0000	1	4			
Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA002				49					
				47015				2					
				48517				47		8			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

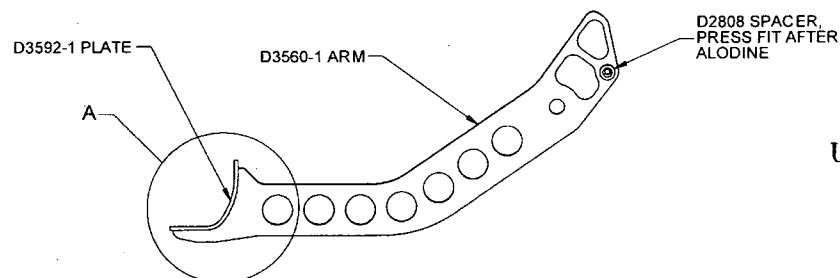
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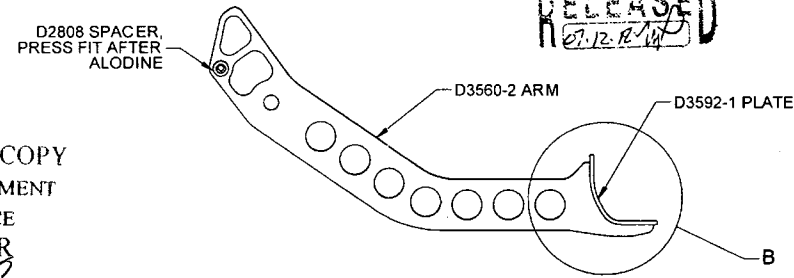
**NOTE:** Date & initial all entries

RELEASED  
07.12.16

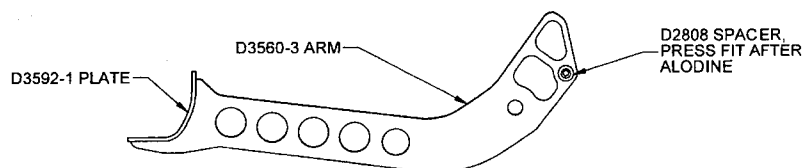
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71950  
*11-07-14*



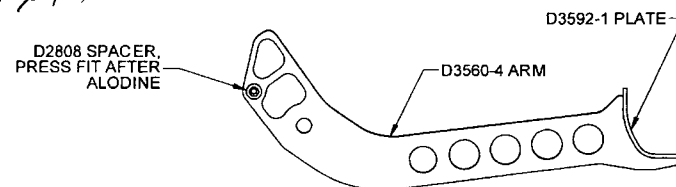
**D3560-041 ARM WELDMENT**



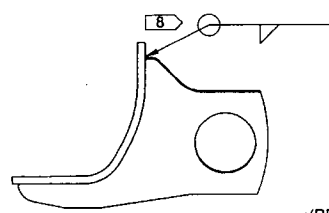
**D3560-042 ARM WELDMENT**



**D3560-043 ARM WELDMENT**



**D3560-044 ARM WELDMENT**



**DETAIL A  
SCALE 1:2**

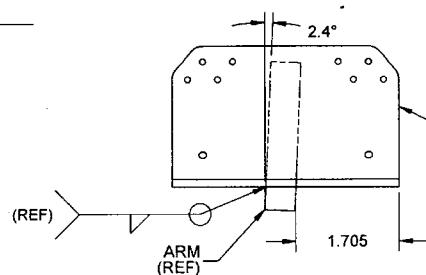
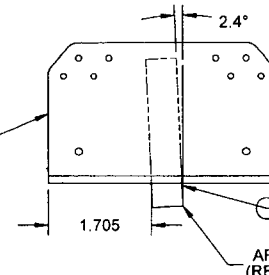
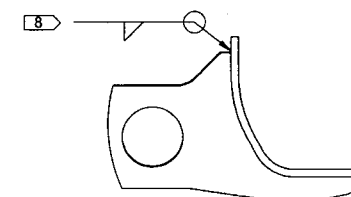


PLATE  
(REF)



ARM  
(REF)



**DETAIL B  
SCALE 1:2**

**PARTS LIST**

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		

- NOTES:**  
 1) MATERIAL: N/A  
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 1.23 lbs (TYP)  
 8) WELDING: PER DART QSI 004

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3560** REV. D  
SHEET 1 OF 5  
TITLE **ARM WELDMENT** SCALE 1:4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

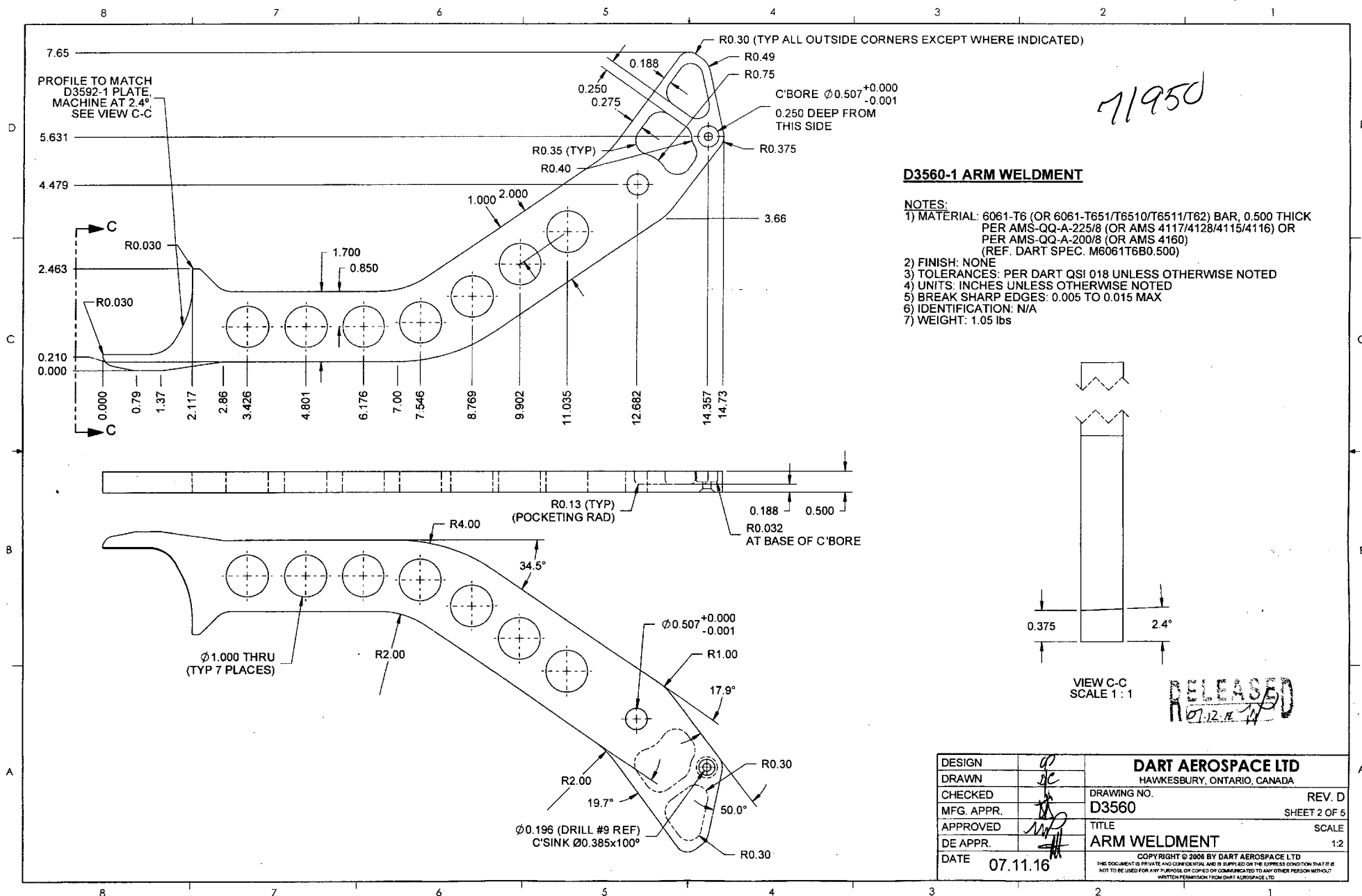
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





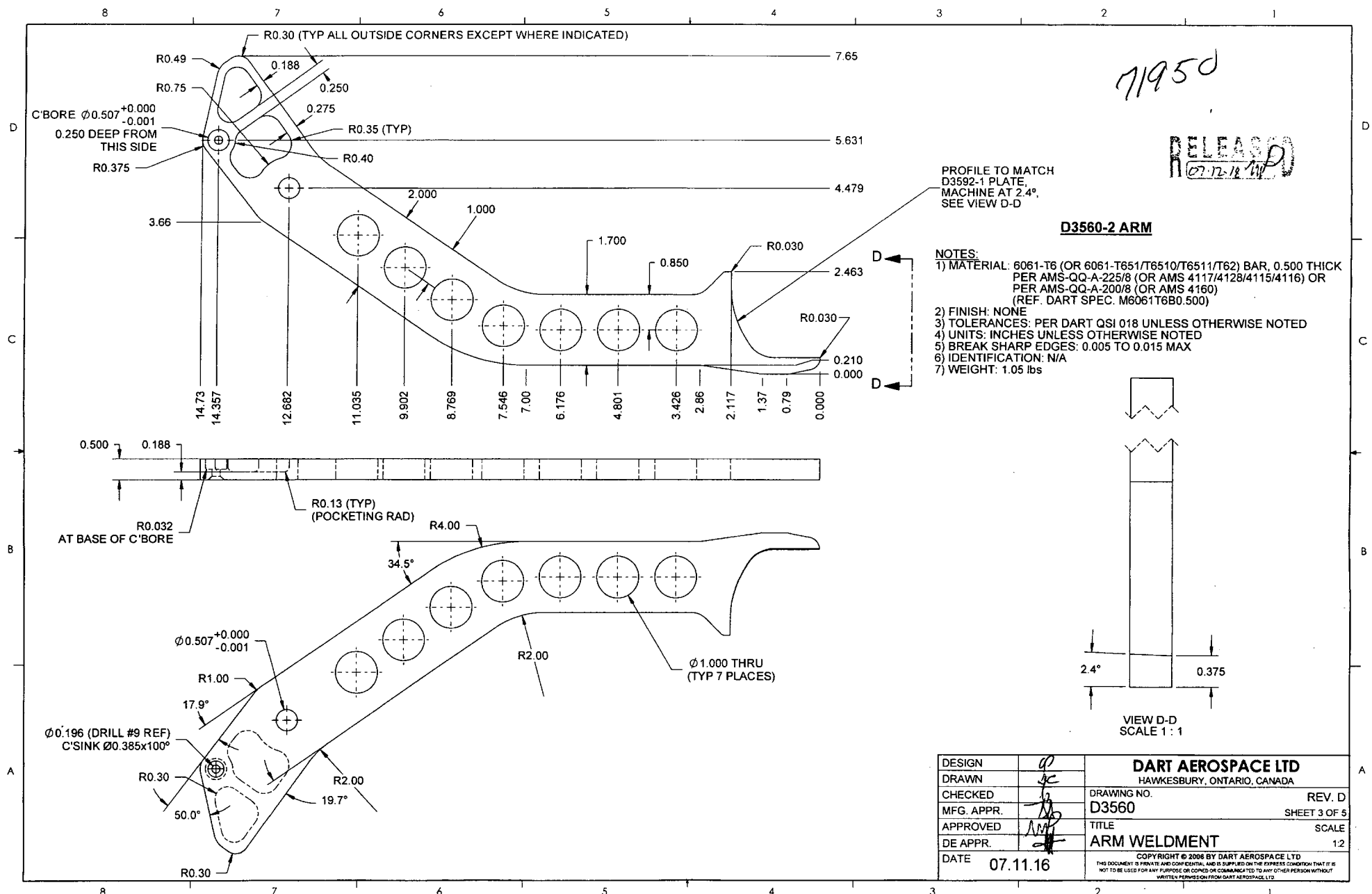
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**NOTE:** Date & initial all entries



DESIGN	71950	<b>DART AEROSPACE LTD</b>	
DRAWN	JC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	<b>D3560</b>	SHEET 3 OF 5
APPROVED	AM	TITLE	SCALE
DE APPR.	JP	<b>ARM WELDMENT</b>	12
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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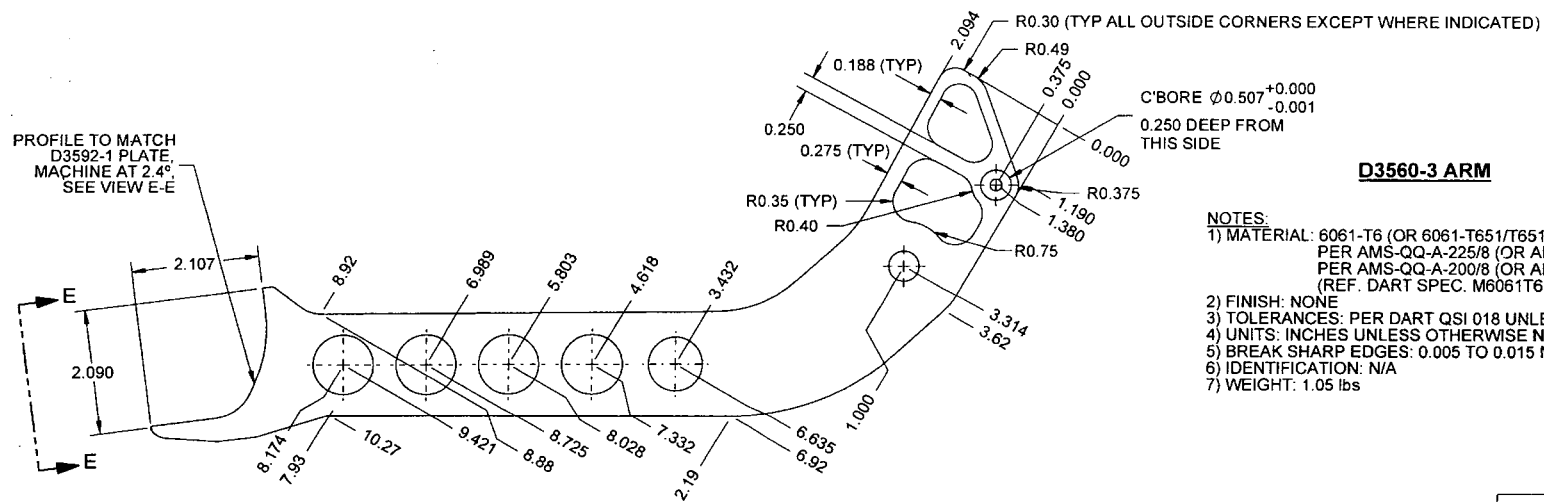
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**NOTE:** Date & initial all entries

PROFILE TO MATCH  
D3592-1 PLATE  
MACHINE AT 2.4°  
SEE VIEW E-E



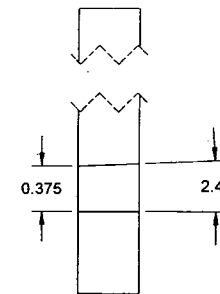
### D3560-3 ARM

#### NOTES:

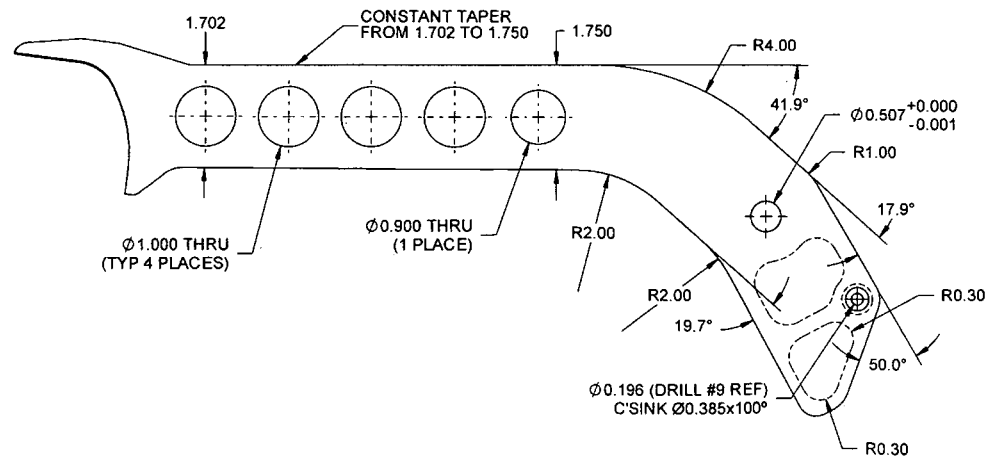
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs

R0.13 (TYP)  
(POCKETING RAD)

0.188  
0.500  
R0.032  
AT BASE OF C'BORE



VIEW E-E  
SCALE 1:1



DESIGN	<i>g</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>EC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AS</i>	D3560	SHEET 4 OF 5
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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RELEASED  
07.12.16

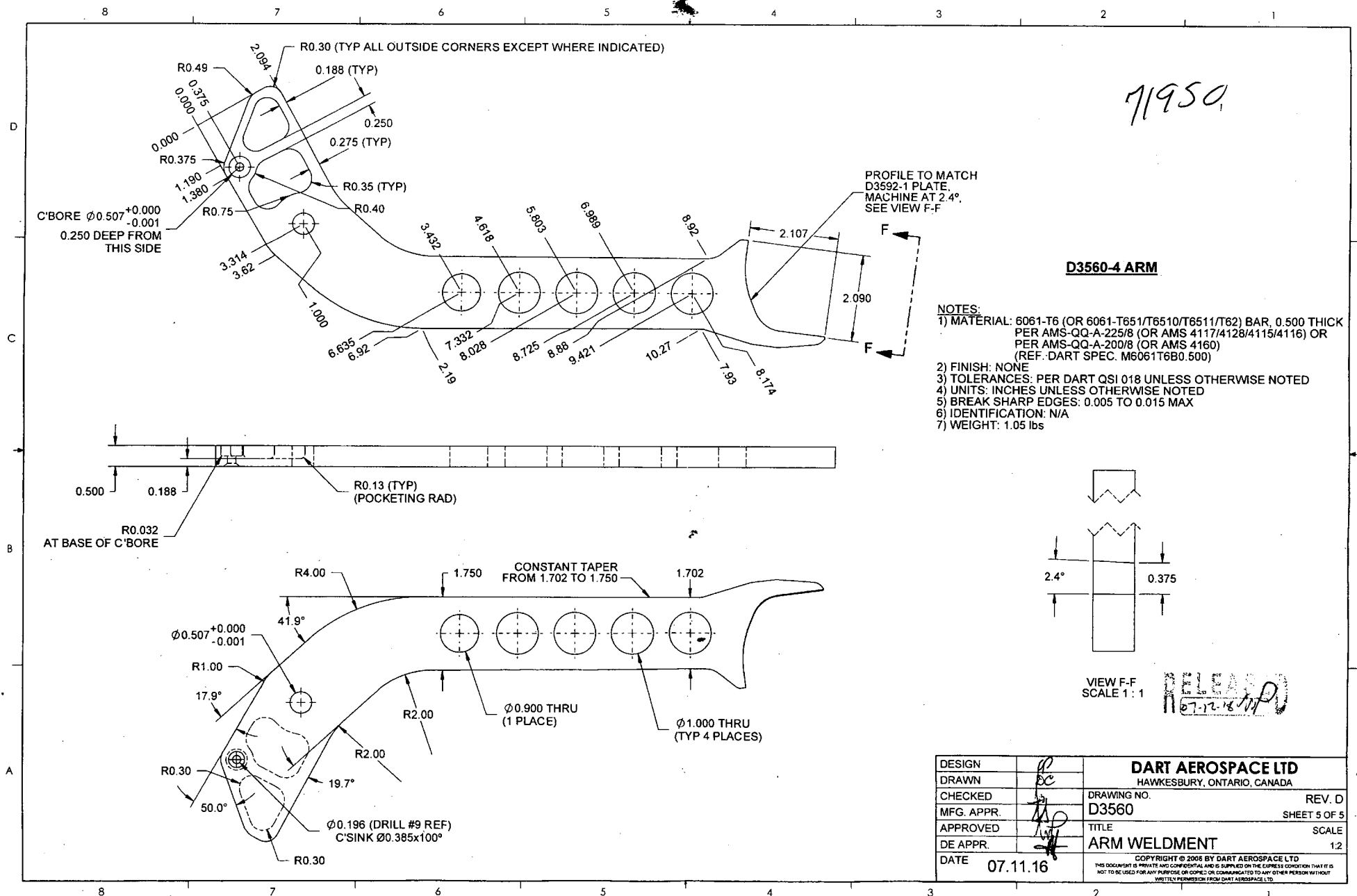
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries